

158425

Wednesday, March 22, 2017 2:18:06 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Run Start *NR1*

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Insp. Stamp

B

100

0.04

100

FLOW WATER JET

0.14

Waterjet

Memo

FLOW CNC Waterjet

1-Cut D3220-2 as per Dwg D3220

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

0.04

QC

Memo

Quality Control

Work Order ID 158425***158425***

Page 2

Wednesday, March 22, 2017 2:18:06 PM

Item ID: D3220-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 3/27/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.08

Quality Control

DAS
38
9-89

MAR 27 2017

130

Small Fab

0.00

130

Small Fab

Memo

0.22

Small Fab

1-Deburr

2-C'sink D3220-2 as per Dwg D3220

4X

DAS
36
9-89
17/03/28

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

DAS
38
9-89

MAR 28 2017

Work Order ID 158425***158425***

Page 3

Wednesday, March 22, 2017 2:18:06 PM

Item ID: D3220-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 3/27/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.45							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.04							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.28							
Small Fab	Assemble D3220-042 doubler as per Dwg D3220								

Work Order ID 158425

158425

Page 4

Wednesday, March 22, 2017 2:18:06 PM

Item ID: D3220-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler Assembly

Start Date: 3/27/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180						4			DAS 38 9-89 MAR 30 2017
QC	Memo	0.08							
Quality Control									
190	Identify as per dwg & Stock Location: <u>ST485</u>	0.00							
190					DAS 6 9-89	4			DAS 41 9-89 MAR 30 2017
Packaging	Memo	0.04							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									17/4/3 JJ
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

MAR 31 2017

Picklist Print

Wednesday, March 22, 2017 2:18:11 PM

Page 1

Work Order ID: 158425

158425

Parent Item: D3220-042

D3220-042

Parent Item Name: Doubler Assembly

Start Date: 3/27/2017

Required Date: 3/29/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

57.4100

0.6926

2.916210

**

PR 17/03/25

M2024T3S 050

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

57.410026

m131564

0.55

m134581

32.1

m135610

24.760026

2.92

MS20426AD3-3

Purchased

No

170

Each

3,641.000

8

32

**

17/03/30

DAS
36
9-89

MS20426AD3-3

RIVET

Location

Loc Qty

Loc Code

fg108

40

M134946

200

M136880

40

GA

1010

M135274

1010

ST312

2391

M135274

2391

32

MS21059L4

Purchased

No

170

Each

22.0000

4

16

**

17/03/30

DAS
36
9-89

MS21059L 4

Nutplate

Location

Loc Qty

Loc Code

ST301

22

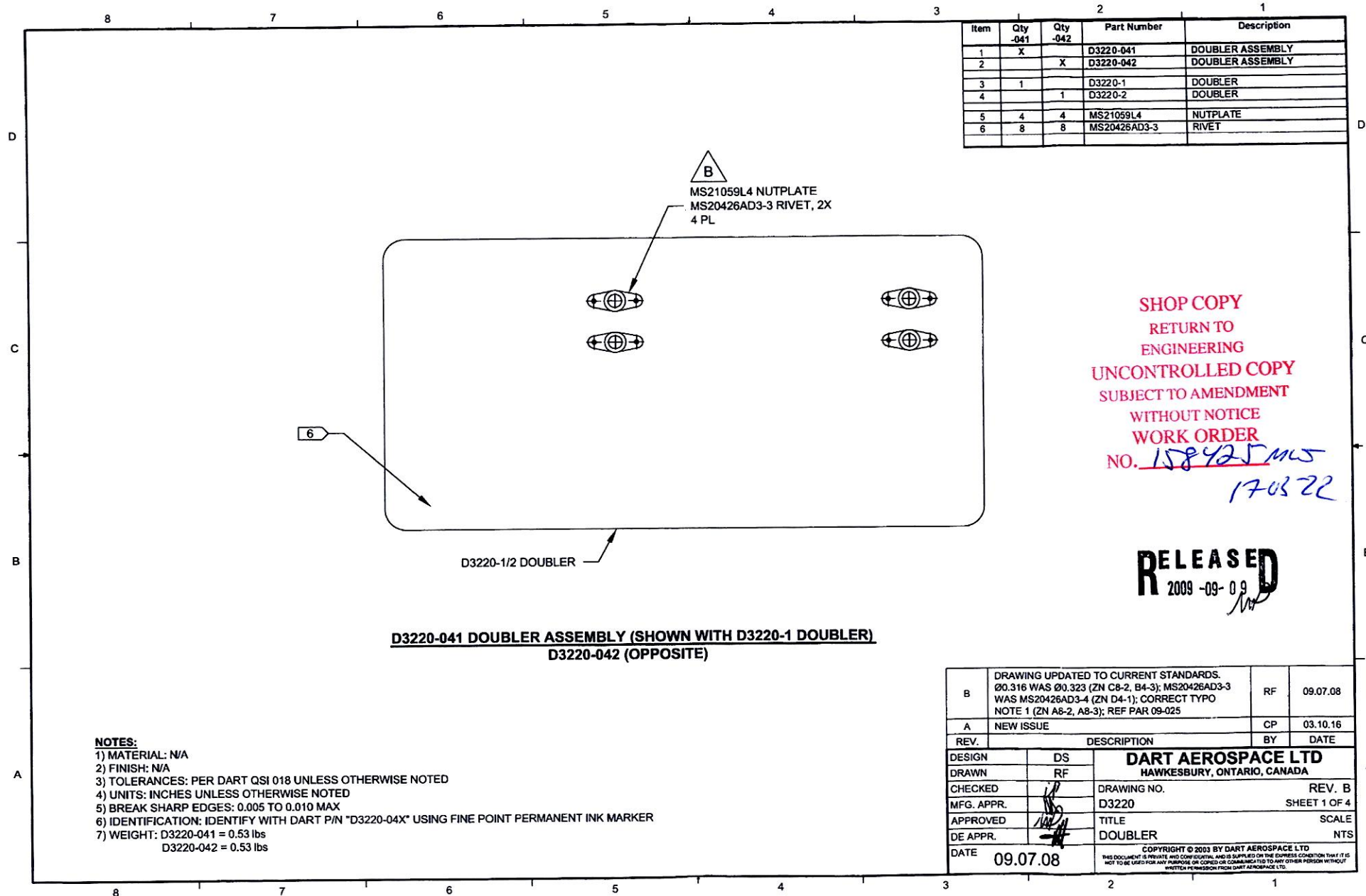
m135766

22

26

M137178

10x



8

7

6

5

4

3

2

1

D

C

B

A

Ø0.098
CSK Ø0.180x100°
NEAR SIDE, 8 PL

B
Ø0.316
TYP, 4 PL

GRAIN
DIRECTION

0.500 TYP

1.000 TYP

R0.50
TYP

14.25

7.000

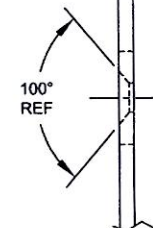
5.50

1.50

1.000

7.00

B1-2
SEE DETAIL A
TYP



DETAIL A
SCALE 5X

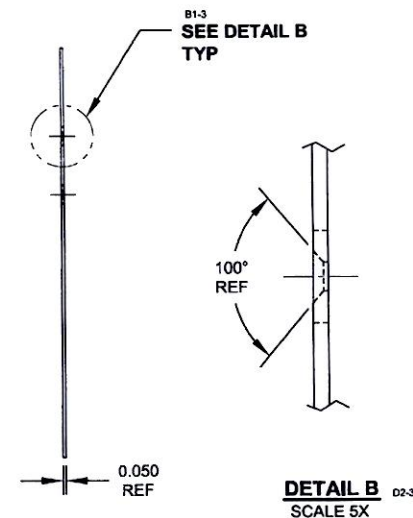
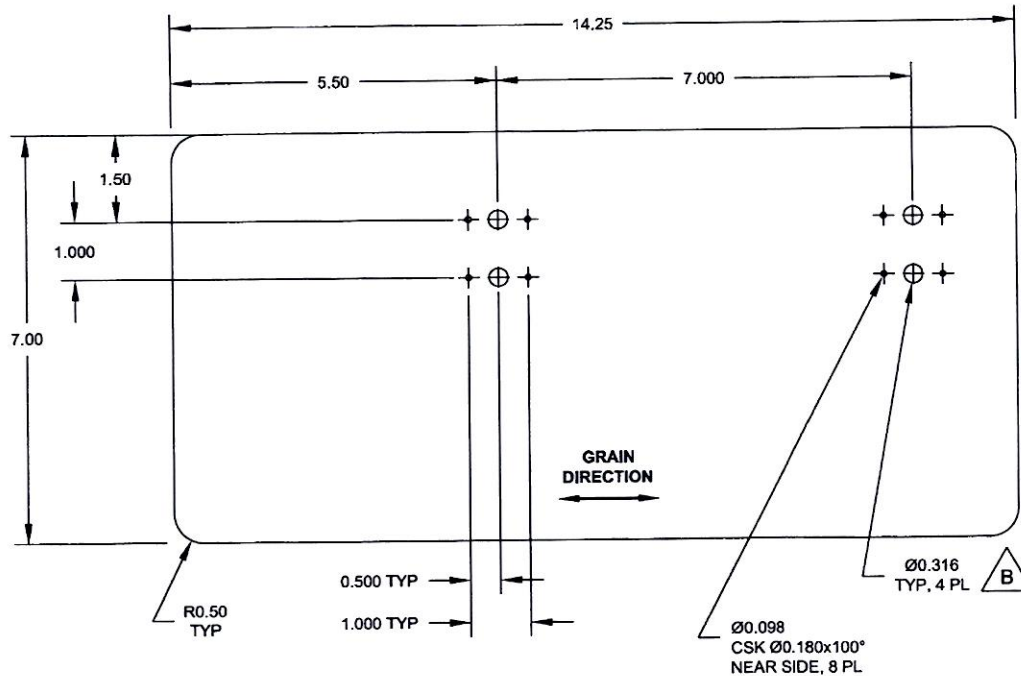
D3220-1 DOUBLER

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3220-2 DOUBLER

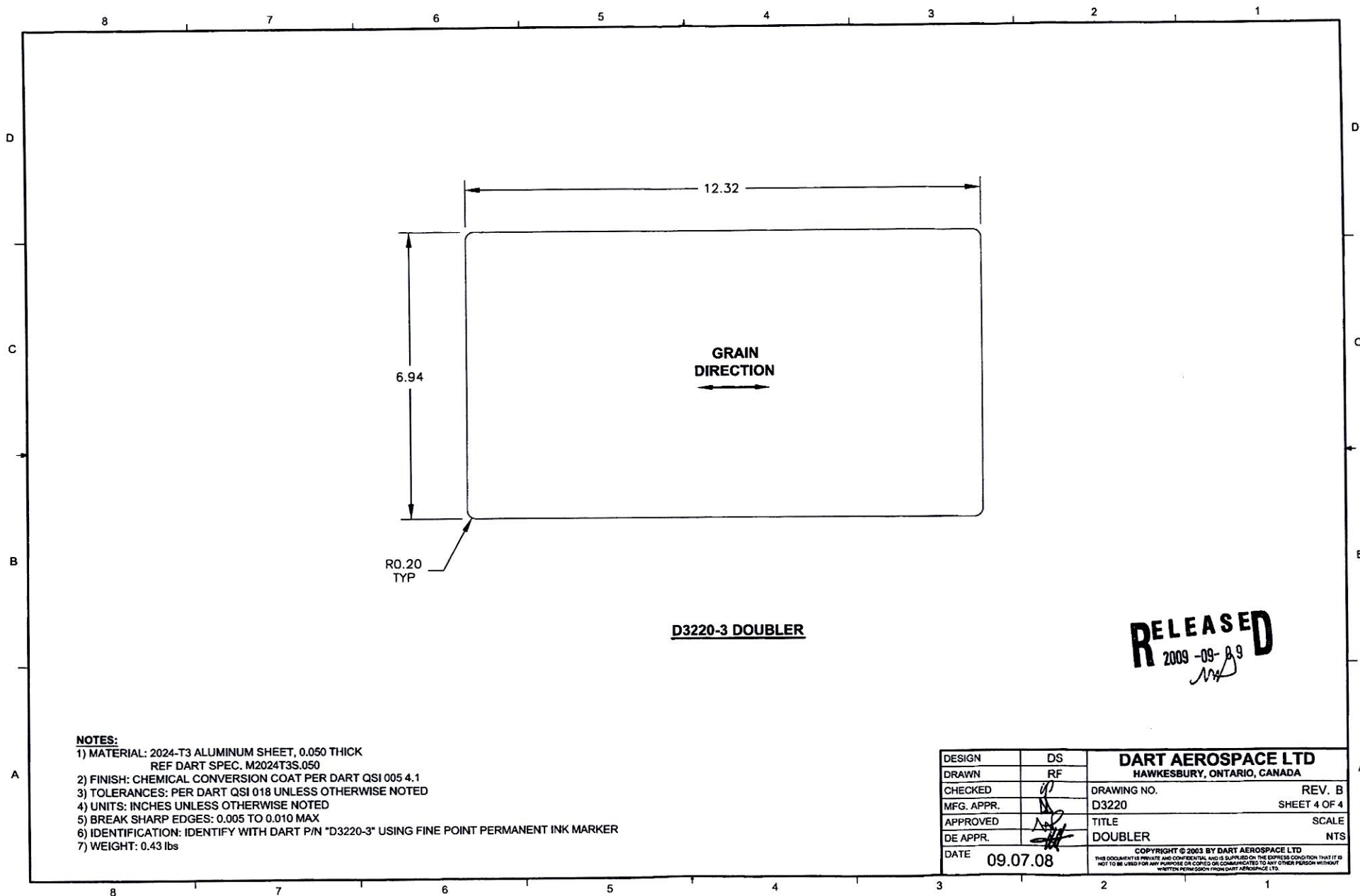
RELEASED
2009-09-09



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-2" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3220-3 DOUBLER

RELEASED
2009-09-09
MA

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MA</i>	D3220	SHEET 4 OF 4
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	